



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA25A-110A
Job Sheet 200362



Part No: SWA25A-110A

Job Qty: 2 pcs

Part Name: Lower End.



Part Weight: 0 lbs

Status: New

Priority: AOG

Job Created: 9/10/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 9/11/19

Description: Order 16887

Type: SOLD

Note: DWG SWA25A-110A A IPP Rev. A 19.09.06 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs		9/11/19	0.00	0.20	Bandsaw - 1		
110	NLX 2500SY - B4B	2 pcs		9/11/19	1.00	2.00	NLX 2500SY - 1 - B4B		
120	QC 2	2 pcs		9/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S212542



Part: SWA25A - 110A

Job No: 200362

Serial No/Batch: S212542

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 09/10/19

Plex 9/10/19 2:31 PM Dart.Renwick.Jennifer

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
125 NV5000 - 1 - B4B	2 pcs	9/11/19	1.00	2.00	NV5000 - 1 - B4B	J.C.L.
					NV5000 - 2 - B4B	
126 QC 2	2 pcs	9/11/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	J.C.L. 19-09-13
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130 QC 8	2 pcs	9/11/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	on 19/09/14
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Bandsaw) Cut blanks to 7.00"

Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FC972 FOLIO REV: AA DWG REV: A
A 2-Deburr 3-***Please see PEC to change engraving batch # for every w/o**

120 - (QC2- Inspect parts off machine FAI/FAIB)

125 - 1-Machine as per folio FC972 FOLIO REV: AA DWG REV: A 2-Deburr

126 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.750	17-4 SS H1150 Round Bar 2.750" <u>Saw</u>	1.1660 ft (.583 ea)	100-Bandsaw - 1	<u>S202396</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R2.750	1	11	0

Part Specifications

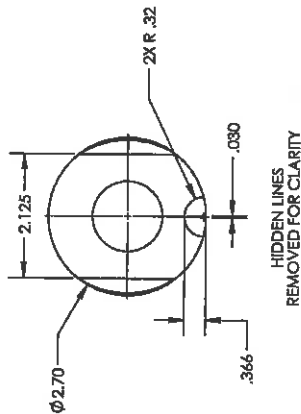
Specifications could not be found.

Plex 9/10/19 2:31 PM Dart.Renwick.Jennifer

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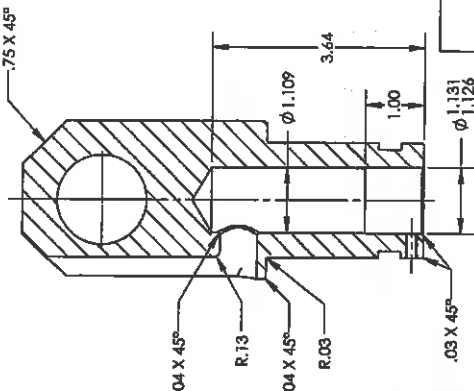
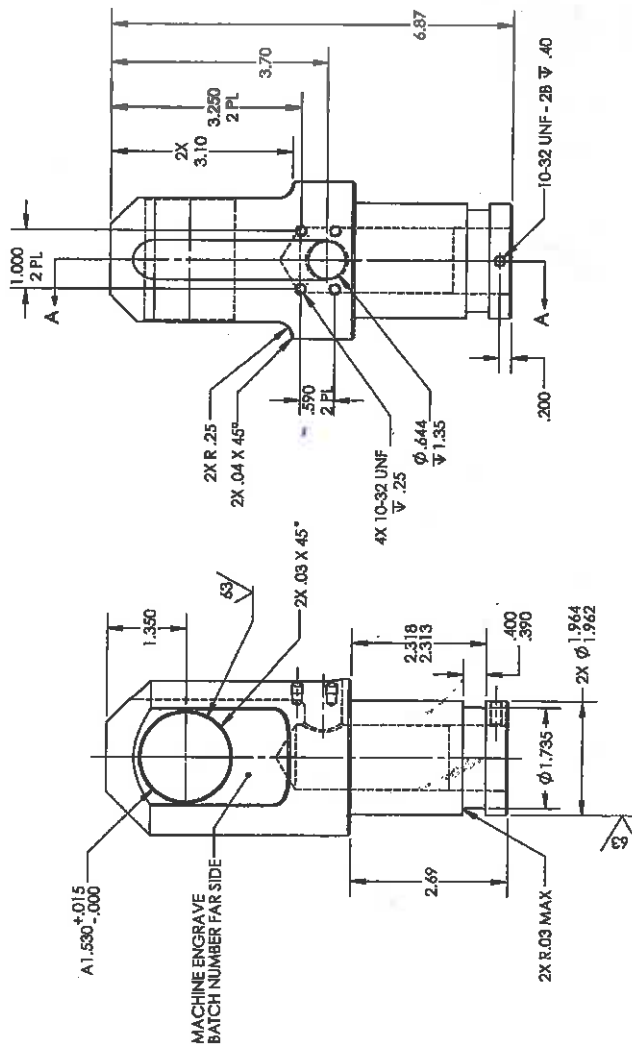
REVISIONS					
REV	ECD	DESCRIPTION	DATE	INITIAL	APPROVED
A		NEW ISSUE	11/12/2012	JAG	

ECN 19-886



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WORK ORDER

NO. 200237 JK 200362



SECTION A-A

[illegible]

ASSY QTY	ASSY QTY	P/W	Description	Material
			LOWER END	S&S 17-4 H13017-4 MICROS

DART AEROSPACE LTD		Work Order:	200 362
Description: Lower End		Part Number:	
Inspection Dwg: SWA25A-110A Rev: A		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	±.015 (-.000)	1.533	✓		Mic LP 05	
1.350	±.005	1.346	✓		H-gauge	
.03x45°	±.000 x.5°	.04x45°	✓		Vern LPID	
2.69	±.01	2.689	✓		H-gauge	
1.735	±.005	1.734	✓		Vern LPID	
1.963	±.001	1.963	✓		Mic LP03	
.395	±.005	.396	✓		Vern LPID	
2.3155	±.0025	2.3145	✓		H-gauge	
Ø2.70	±.01	2.699	✓		Vern LPID	
2.125	±.005	2.124	✓		↓	
.366	±.005	.365	✓		Caliper	JCL-08
.030	±.005	0.030	✓			
R.32	±.01	0.322	✓		R.N Gauge	
1.000	±.005	1.000	✓		Caliper	JCL-08
R.25	±.010	.25	✓		Rad gauge	
.04x45°	±.01 x.5°	0.030	✓			
10-32UNF-28	GO-N660	C.K.	✓		GO-N660	
.25	±.01	0.260	✓			
Ø.644	±.005	0.644	✓		Caliper	JCL-08
1.35	±.01	True	✓			
.200	±.005	.200	✓		H-gauge	
3.10	±.01	3.096	✓		↓	
3.25	±.01	3.252	✓			
3.70	±.01	3.700	✓		Caliper	JCL-08
6.87	±.01	6.870	✓		H-gauge	
R.13	±.01	0.130	✓		Rad. Gauge	
.04x45°	±.01 x.5°	.04x45°	✓		Vern LPID	
R.03	±.01	.032	✓		Rad gauge	
.03x45°	±.01 x.5°	.03x45°	✓		Vern LPID	

Measured by: J.C.L.	Checked by: [Signature]	QC Inspector:
Date: 19-07-13	Date: 19/08/14	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

